



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3572-041
Job Sheet 179750



Part No: D3572-041

Job Qty: 3 pcs

Part Name: Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP Rev:A New Issue 07-02-07 JLM IPP rev B revB dwg EC IPP Rev:C Removed D3572-7 Cap
07-06-11 JLM IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		7/18/18	0.00	0.00	Start Up Large Fab-1		JBL
110	Large Fab - Welded Assy-1	3 pcs		7/18/18	0.00	0.81	Large Fab 8		JBL
120	QC 5	3 pcs		7/18/18	0.00	0.00	QC5		EL
130	Large Fab - Welded Assy-2- B4B	3 pcs		7/18/18	0.00	2.91	Large Fab - 1 - B4B Large Fab - 10 - B4B Large Fab - 2 - B4B Large Fab - 3 - B4B Large Fab - 4 - B4B Large Fab - 5 - B4B Large Fab - 6 - B4B Large Fab - 7 - B4B Large Fab - 8 - B4B Large Fab - 9 - B4B		EL
140	QC 9	3 pcs		7/18/18	0.00	0.00	QC9		DAS 43 9-89
150	QC 5	3 pcs		7/18/18	0.00	0.00	QC5		DAS 43 9-89
180	Handfinish - 1-1 Chemical- B4B	3 pcs		7/18/18	0.00	0.27	HandFinish1		JUN 24 2019
190	Powdercoat - 3 Grey Sand - B4B	3 pcs		7/18/18	0.00	0.19	Powdercoat3		DAS 81 9-89
200	QC 3	3 pcs		7/18/18	0.00	0.00	QC3		JUN 27 2019
210	Packaging 3-1 - Stock - B4B	3 pcs		7/18/18	0.00	0.00	Packaging3-1		DAS 28 9-89
220	QC 21 - SA	3 pcs		7/18/18	0.00	0.00	QC21		JUN 28 2019

Part Op 110 - 1-Cut Tube D3572-1 as per Dwg D3572 2-deburr both ends

Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)

130 - (Weld per dwg A/R Aluminum rod Batch: 14785***USE DT8947 DT8944*** 1-Weld D3572-5 bracket to D3572-1 as per Dwg D3572 2- Grind weld flush at the end of tube only 3- Weld D3572-3 guides to D3572-1 as per dwg

140 - (QC9- Inspect visual per QSI004- Fusion Welds)

150 - (QC5- Inspect part completeness to step on W/O)

180 - (Chemical Conversion Coat per QSI005 4.1)

190 - (Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3) START TIME: 9:15 OVEN TEMPERATURE: 320°

FINISH TIME: 9:45 11/18/839

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: _____)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T1.000W.188	6061T6 Round Tube 1.00 X .188W	6.0295 ft (2.0098333 ea)	90-Start up Operation	5082403
D3572-3	Guide	12 pcs (4 ea)	130-Large Fab - Welded Assy-2- B4B	5089561
D3572-5	Bracket	3 pcs (1 ea)	130-Large Fab - Welded Assy-2- B4B	5058813

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T1.000W.188	6	22	0
130-Large Fab - Welded Assy-2- B4B	D3572-3	12	84	0
	D3572-5	3	12	0

Part Specifications
Specifications could not be found.



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90	Start up Operation	6 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Large Fab-1		JBL
110	Large Fab	6 pcs	7/18/18	7/18/18	0.00	1.63	Large Fab 8		JBL
120	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC5		EL
130	Large Fab	6 pcs	7/18/18	7/18/18	0.00	5.83	Large Fab 2		
140	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC9		
150	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC5		
180	HandFinish	6 pcs	7/18/18	7/18/18	0.00	0.55	HandFinish1		
190	Powdercoat	6 pcs	7/18/18	7/18/18	0.00	0.39	Powdercoat3		
200	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC3		
210	Packaging	6 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-1		
220	QC21-SA	6 Ea	7/18/18	7/18/18	0.00	0.00	QC21		

Part Op 110 - 1-Cut Tube D3572-1 as per Dwg D3572 2-deburr both ends

Descriptions: 130 - ***USE DT8947 DT8944*** 1-Weld D3572-5 bracket to D3572-1 as per Dwg D3572 2- Grind weld flush at the end of tube only 3- Weld D3572-3 guides to D3572-1 as per dwg

190 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T1.000W.188	6061T6 Round Tube 1.00 X .188W	14.0400 ft (2.34 ea)	90-Start up Operation	
D3572-3	Guide	24 Ea (4 ea)	130-Large Fab	
D3572-5	Bracket	6 Ea (1 ea)	130-Large Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T1.000W.188	14	52	0
130-Large Fab	D3572-3	24	38	0
	D3572-5	6	6	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																					
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																																																																			
Description Work Order 1270 Aberdeen Street Hemel Hempstead, Herts AL6 1K7 CANADA TEL : 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/12/18 Container No: S090998 Part: D3572 - 041 Job No: 179750 Serial No/Batch: S090998 Revision: Inspector: Exp Date: Instructions:																																																																																																																							
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